

Work Order ID 72885

Wednesday, August 17, 2011 2:42:49 PM



Page 1

Item ID: D2939-2

Accept



Setup Start



Revision ID:

Item Name: Saddle RH In, 206

Stop



Start Date: 8/17/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 8/17/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2939

Rev C

100



HAAS I

HAAS CNC VERTICAL MACHINING #1

0.00

BA/ML 11/08/24

6 0

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110



Mill Conv

CONVENTIONAL MILLING MACHINE

0.00

ML 11/08/24

6 0

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120



QC

QC1- Inspect dimensions to dimension sheet

0.00

ML 11/08/24

6 0

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

22 11.8.25

6 0

6X Ø M-11/08/25

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

10:20

3200F

10:50

6X Ø M-11/08/26

M117745

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72885

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Page 3

Item ID: D2939-2

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Item Name: Saddle RH In, 206

Stop



Start Date: 8/17/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							
170 	Identify as per dwg & Stock Location	0.00							
Packaging Packaging	Memo	0.00							
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

lex 11-08-29

11/8/29

11-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 17, 2011 2:42:55 PM

Page 1

Work Order ID: 72885

Parent Item: D2939-2

Parent Item Name: Saddle RH In, 206


Start Date: 8/17/2011

Start Qty: 6.00

Required Date: 8/25/2011

Required Qty: 6.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	73.0000	1	6			

Saddle Billet

Location	Loc Qty	Loc Code
MAT040	73	
64777	20	
66965	1	
69677	2	
70976	10	
✓ 72225	40	

6.0

B.A 11/08/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 72885
Description: 206 Saddle, Inboard, Right side		Part Number: D2939-2
Inspection Dwg: D2939	Rev: C	Page 1 of 1

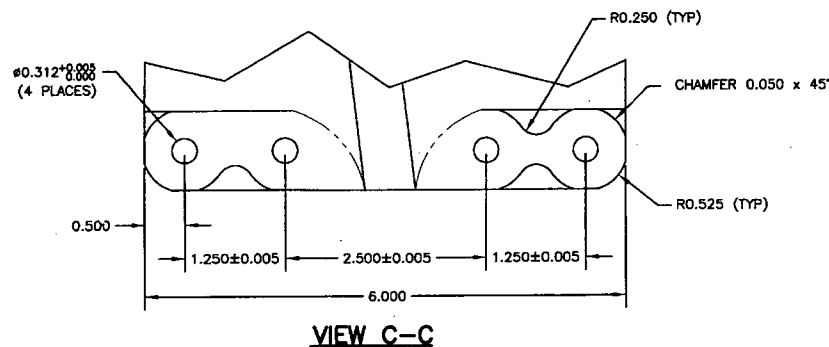
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Gage / Gauge /	#2	#3	#4	#5	#6
A	0.100	0.140	.110	.112	.110	.110	.109	.110
B	0.100	0.140	.103	.106	.104	.104	.104	.104
C	0.100	0.140	.118	.118	.116	.117	.117	.117
D	0.210	0.230	.219	.220	.220	.217	.218	.218
E	1.245	1.255	1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255	1.250	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505	2.500	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515	.511	.510	.510	.511	.511	.511
I	1.572	1.582	1.578	1.578	1.578	1.578	1.578	1.578
J	2.495	2.505	2.500	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262	.258	.258	.258	.258	.258	.258
L	0.312	0.317	.314	.314	.314	.314	.314	.314
M	0.235	0.240	.238	.237	.237	.237	.238	.238
N	0.100	0.140	.110	.110	.110	.108	.108	.108
O	0.540	0.560	.548	.548	.549	.550	.547	.548
P	0.490	0.510	.501	.500	.500	.502	.500	.500
Q	3.715	3.725	3.720	3.720	3.720	3.720	3.720	3.720
R	2.720	2.760	2.740	2.740	2.740	2.740	2.740	2.740
S	0.240	0.270	.246	.249	.248	.249	.249	.249
T	0.100	0.180	.133	.133	.133	.133	.133	.133
U	1.625	1.635	1.630	1.630	1.630	1.630	1.630	1.630
V	1.362	1.372	1.367	1.368	1.368	1.368	1.368	1.368
W	0.316	0.321	.316	.316	.316	.316	.316	.316
X	1.250	1.270	1.261	1.261	1.261	1.260	1.257	1.257
Y	1.565	1.585	1.574	1.578	1.572	1.572	1.570	1.570
Z	0.178	0.198	.188	.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: <i>OMK</i>	Date: 11/08/24
Audited by: <i>RP</i>	Date: 11.8.25
Prototype Approval: N/A	Date: N/A

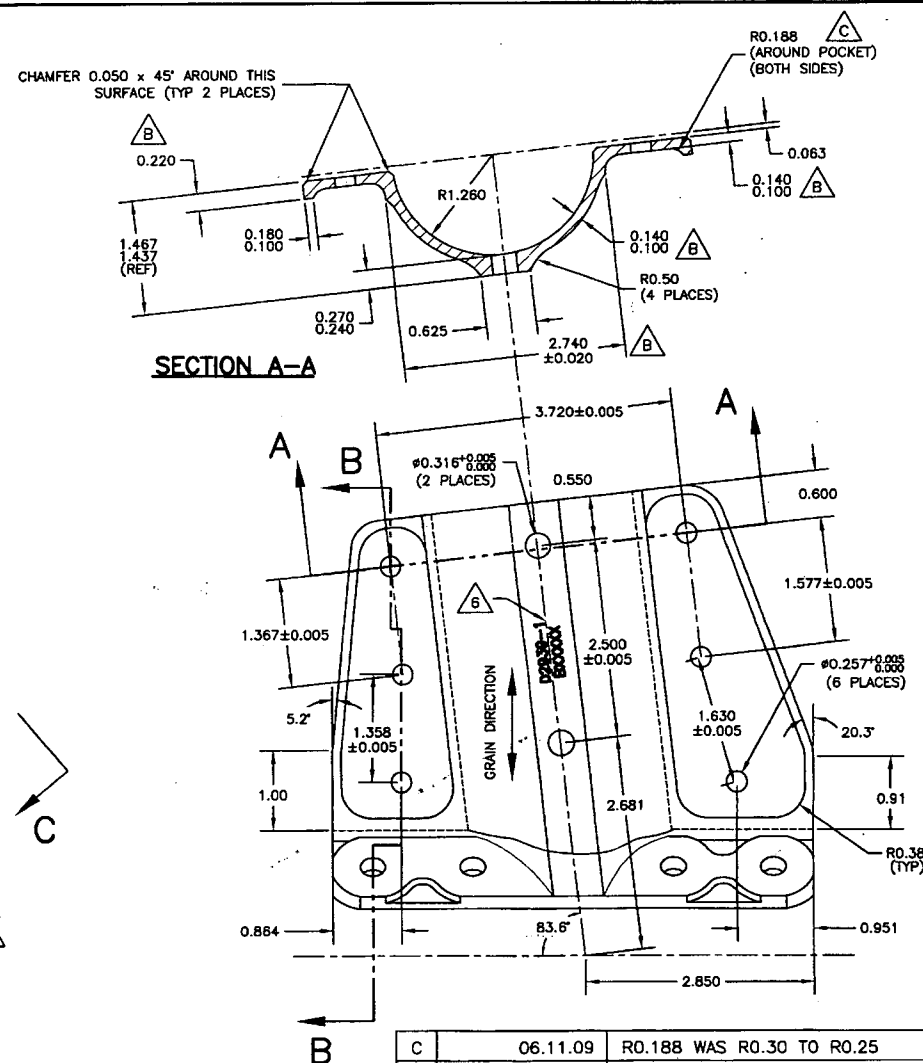
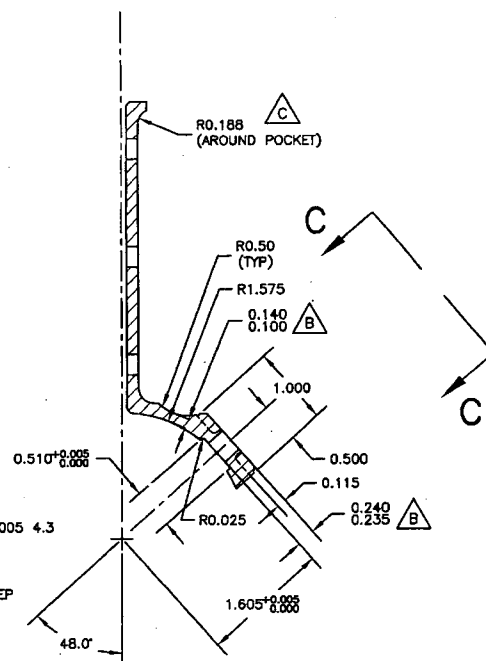
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	<i>JA</i>



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY: CB	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED: PH	APPROVED: PH	DRAWING NO. D2939
DATE: 06.11.09	TITLE: SADDLE INSIDE	REV. C SHEET 1 OF 1 SCALE: 2:3

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